

shp 24/03

Date: Wednesday, 19/03/2008 10:35:19 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BALL STUD
Job Number : 38113	
Estimate Number : 12841	
P.O. Number :	Part Number : D36221
This Issue : 19/03/2008 S.O. No. :	Drawing Number : D3622 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33570	Material :
Written By :	Due Date : 24/03/2008 Qty: 40 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-04-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR
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Comment: Qty.: 0.1134 f(s)/Unit Total : 4.5360 f(s)
- 303 HEX BAR .500"
Batch: M106789

J.F. 08/03/24

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1-TURN AS PER FOLIO FA686 & DWG D3622 ,
FOLIO REV: AA
DWG REV: A

2-DEBURR AS REQUIRED

J.F. - 08/03/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/03/24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/03/24

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST114

AS 08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BALL STUD

Job Number: 38113

Part Number: D36221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(48)

Comment: FINAL INSPECTION/W/O RELEASE

D08/03/06

Job Completion



W 08-03-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

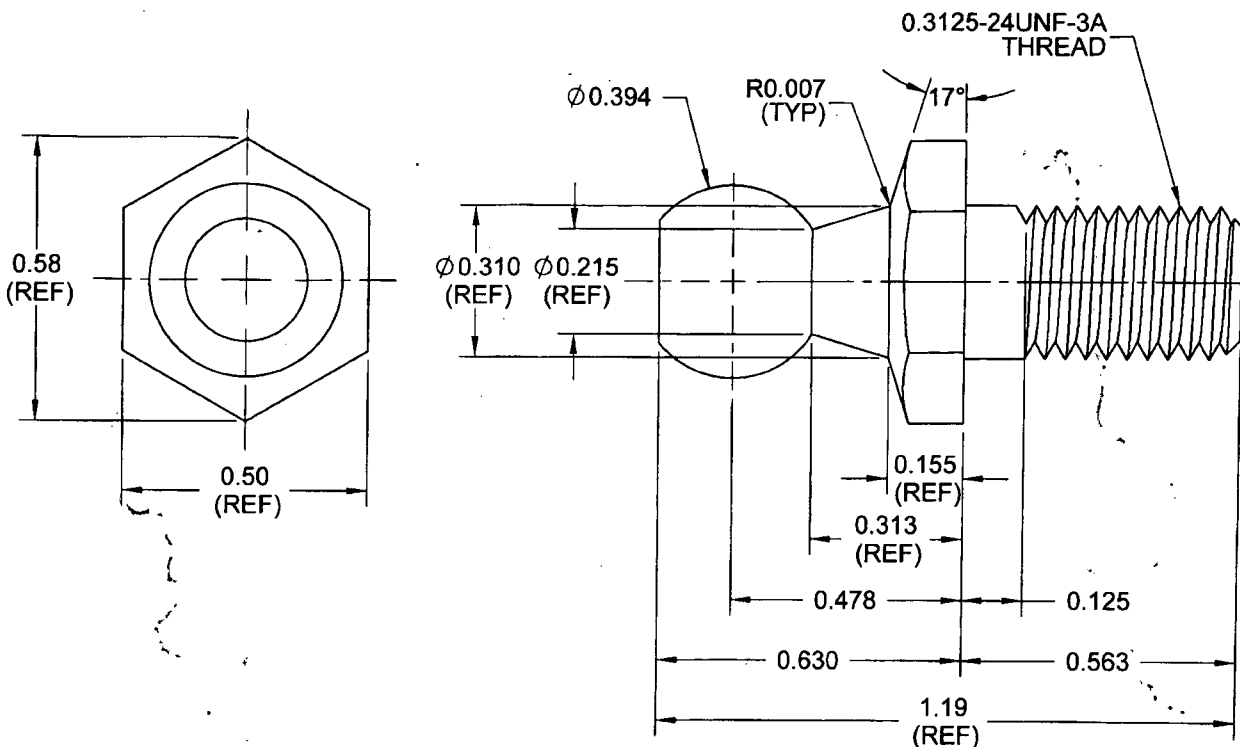
NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3622	REV. A SHEET 1 OF 1
DATE 07.04.13	TITLE BALL STUD		SCALE NTS
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

RELEASED
07.07.11

PER BCN# 1001



D3622-1 BALL STUD

also 38118

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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